

Work Order ID 106346

August-29-13 1:27:58 PM

106346

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Item ID:	D4035-043	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:							
Item Name:	Lid Rib Assembly, Aft (350 Basket)					*NS2*	
Start Date:	8/29/13	Start Qty:	8.00	*8*	Cust Item ID:		
Required Date:	9/12/13	Req'd Qty:	8.00	*8*	Customer:		
Reference:							
Approvals:	Process Plan: <u>MU5</u>	Date: <u>13-08-29</u>	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								
100	Weld per dwg A/R S.S. rod Batch: <u>4123823</u>	0.00							
100 Large Fab	Memo	0.00							
	1- Cut D4035-3 as per dwg D4035 2- Drill holes using DT9563 and chamfer holes as per dwg D4035 3- remove identification marks and deburr 4- Weld bushing in rib and grind weld flush as per dwg D4035								
110	QC10- Inspect visual per QSI004- ground welds	0.00							
110 QC	Memo	0.00							
Quality Control									

Q 13-09-04 DAS 09-09

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Item ID: D4035-043 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Lid Rib Assembly, Aft (350 Basket) Stop *NS2*

Start Date: 8/29/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 9/12/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

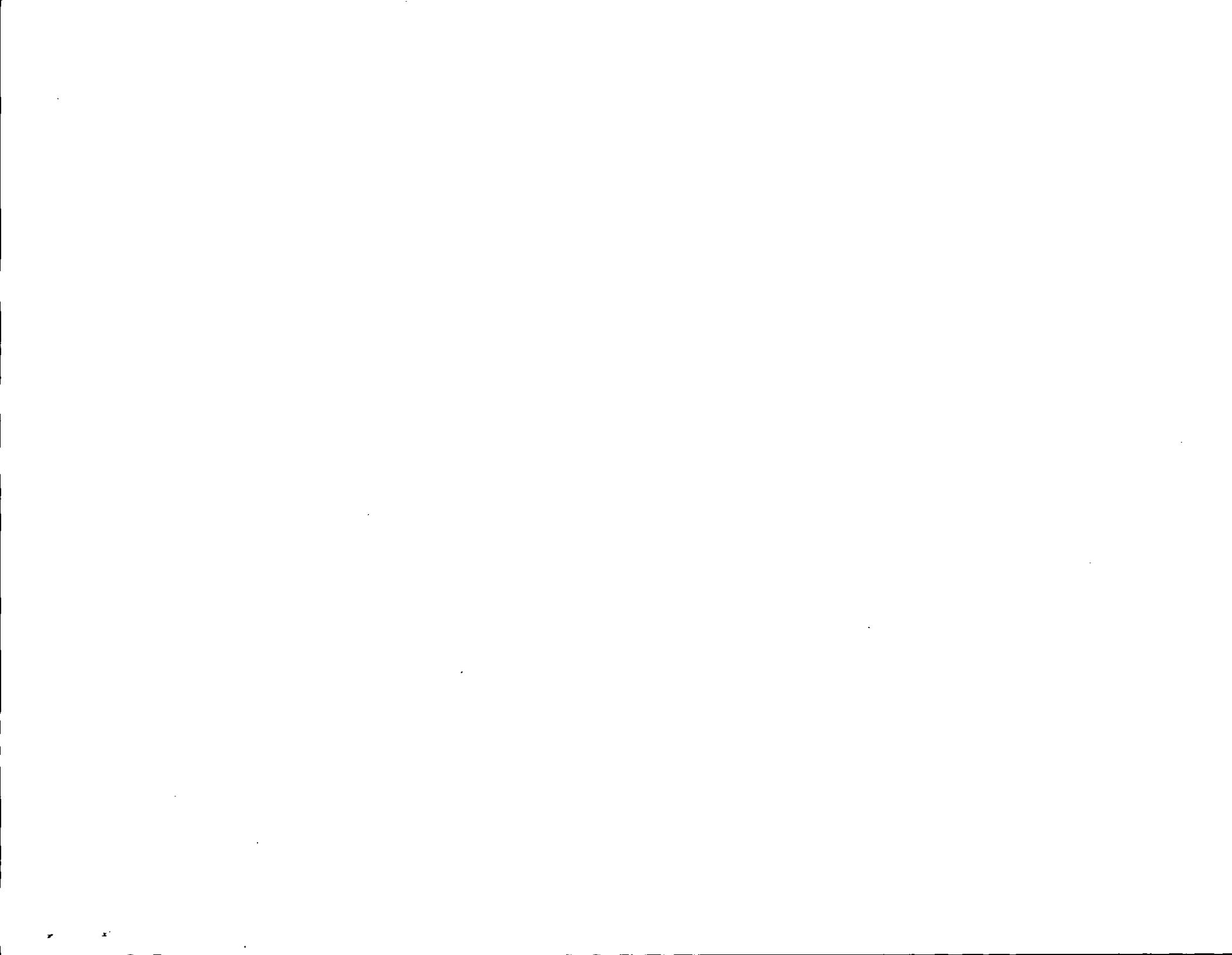
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00							13-09-06 09:09

130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Basket 411004 Memo	0.00	9x	13-09-08
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140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00	13-09-08
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Picklist Print

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Work Order ID: 106346

106346

Parent Item: D4035-043

D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 8/29/13

Required Date: 9/12/13

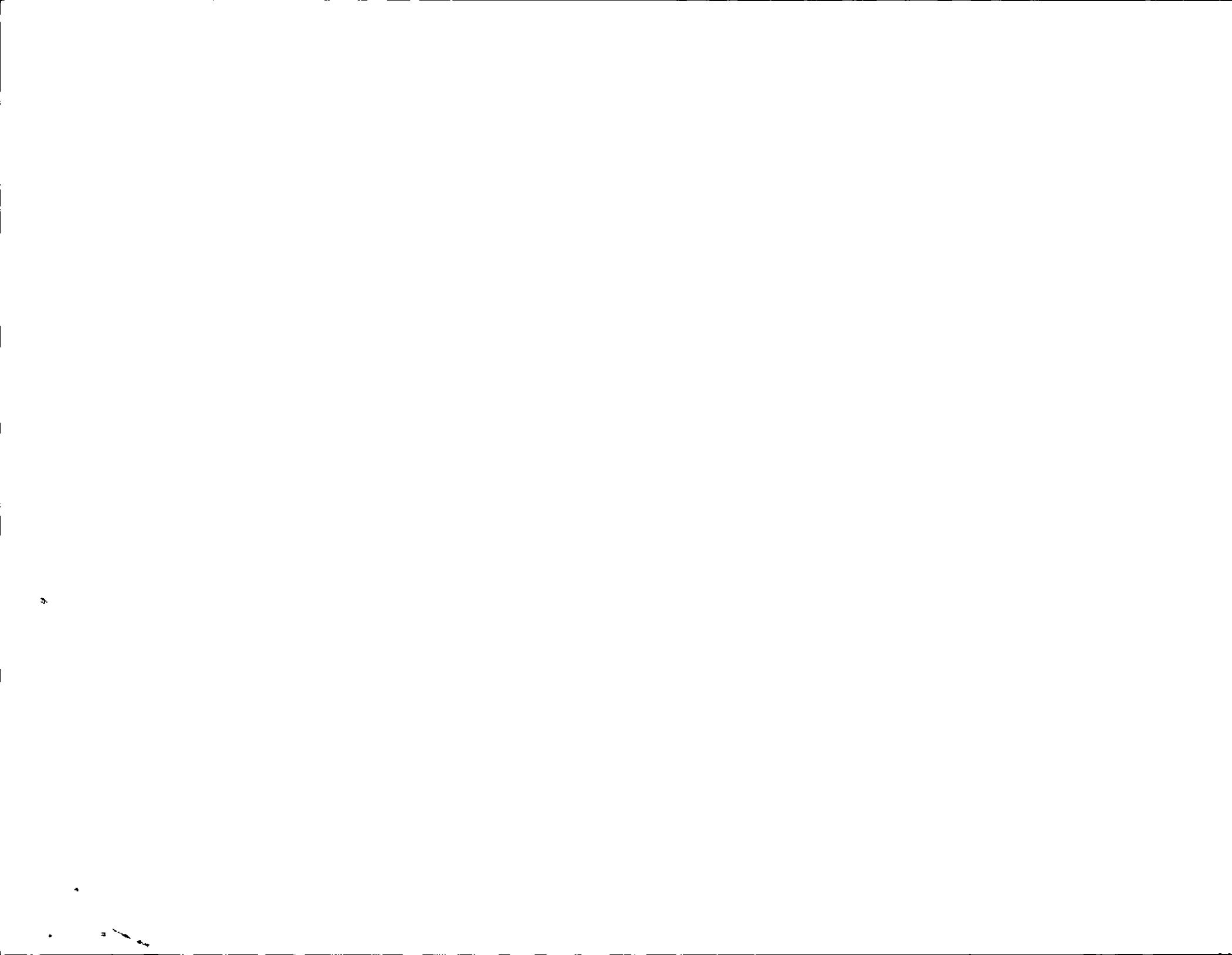
Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
 per dwg revA 10.03.15 verified by:EC IPP Rev:C 13.06.24 AS
 PER DWG REV.pb2 DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9 *D4021-9* Bushing		Manufactured	No			100	Each	211.0000	2	16			**

Location	Loc Qty	Loc Code
WA002	6	
102482	4	
99143	2	
WA004	205	
100402	29	18x
100917	40	
102664	76	
66437	2	
70333	4	
72482	4	
82977	1	
84717	3	
88077	23	
88377	7	
92020	12	
98877	4	



Picklist Print

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Work Order ID: 106346

106346

Parent Item: D4035-043

D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 8/29/13

Required Date: 9/12/13

Start Qty: 8.00

Required Qty: 8.00

M304TS0.750W.049

Purchased

No

100

f

1,108.839

1.75

14.73684

**

M126039

304 SQ Tube .75x.75x.049W

M304TS0 750W 049

Location	Loc Qty	Loc Code
WA006	1108.839733	
123484	2.95828950	
125124	205.405667	
125575	122.882777	
M126039	177.593	
M126364	600	

13.09.04

NCR: Yes / No

DQA: _____ Date: _____

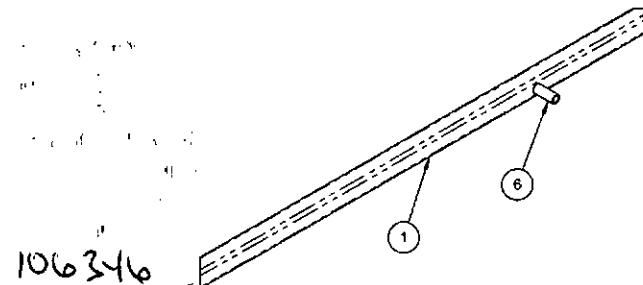
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced						
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure						
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld						
	Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled						
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>							
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other						
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>								
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

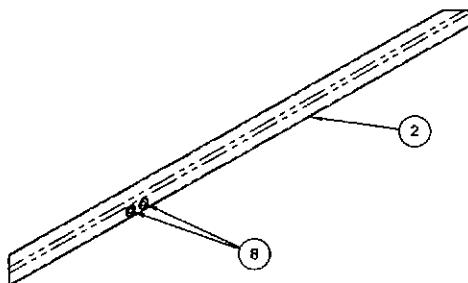


ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
	X				D4035-043	LID RIB ASSY, AFT
		X			D4035-045	LID RIB ASSY, FWD (LIGHT)
			X		D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3		1			D4035-5	RIB
4			1		D4035-7	RIB
5			2		D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7		1			D2953-175	SPACER
8		2			D4021-9	BUSHING

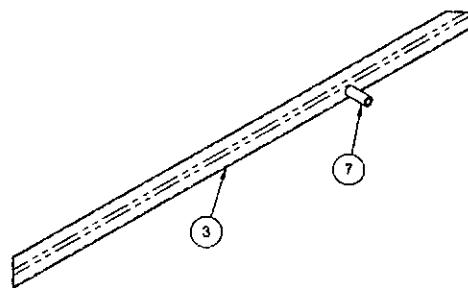


D4035-041 BASKET LID RIB ASSY, FWD

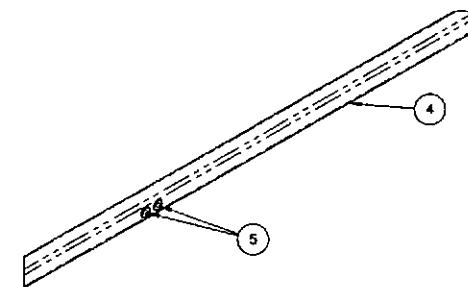
13-08-29



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

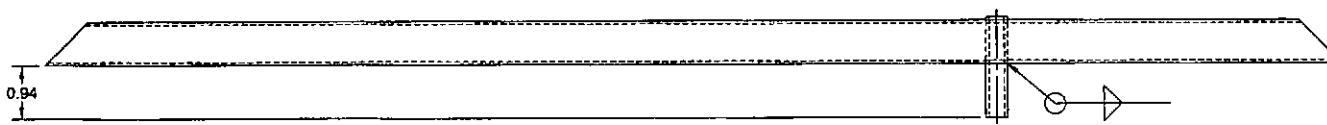


D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

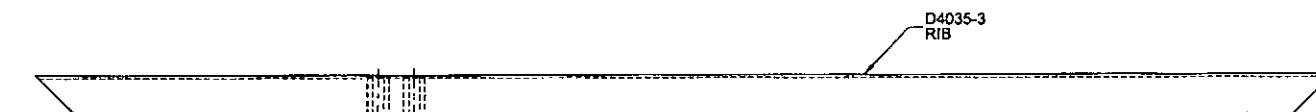
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R 2010-03-12
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A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	BASKET LID RIB ASSY	NTS
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D4035-041 BASKET LID RIB ASSY, FWD



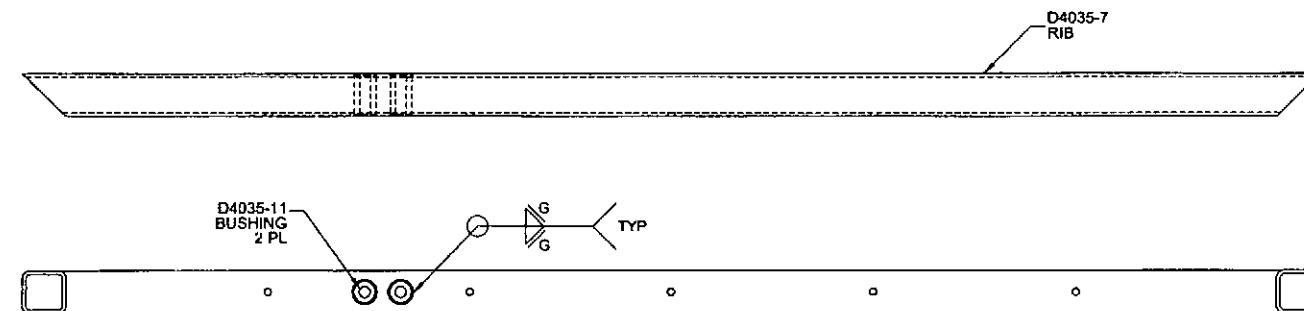
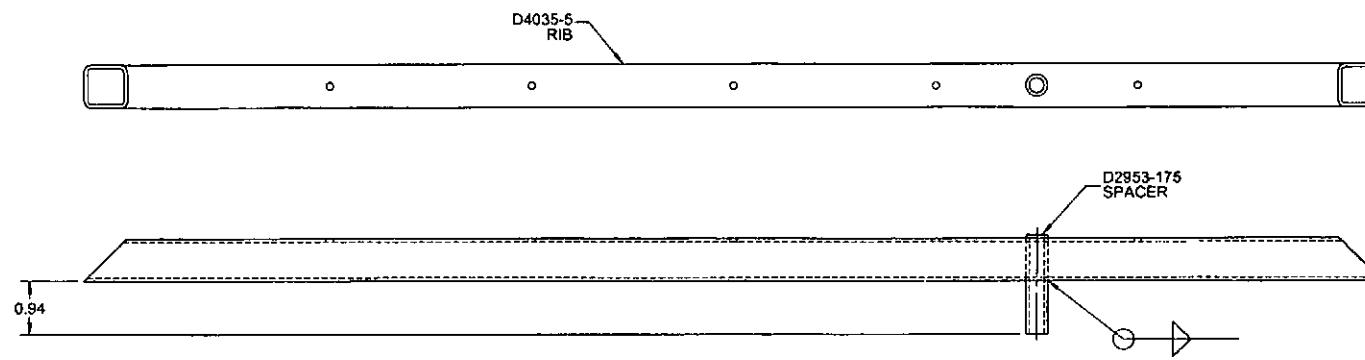
D4035-043 BASKET LID RIB ASSY, AFT

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART C
4) UNITS: INCHES UNLESS OT
5) BREAK SHARP EDGES: 0.00
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs
8) WELDING: PER DART QSI 00

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MFG. APPR.		D4035	SHEET 2 OF 5	
APPROVED	M	TITLE	SCALE	
DE APPR.	H	BASKET LID RIB ASSY	NTS	
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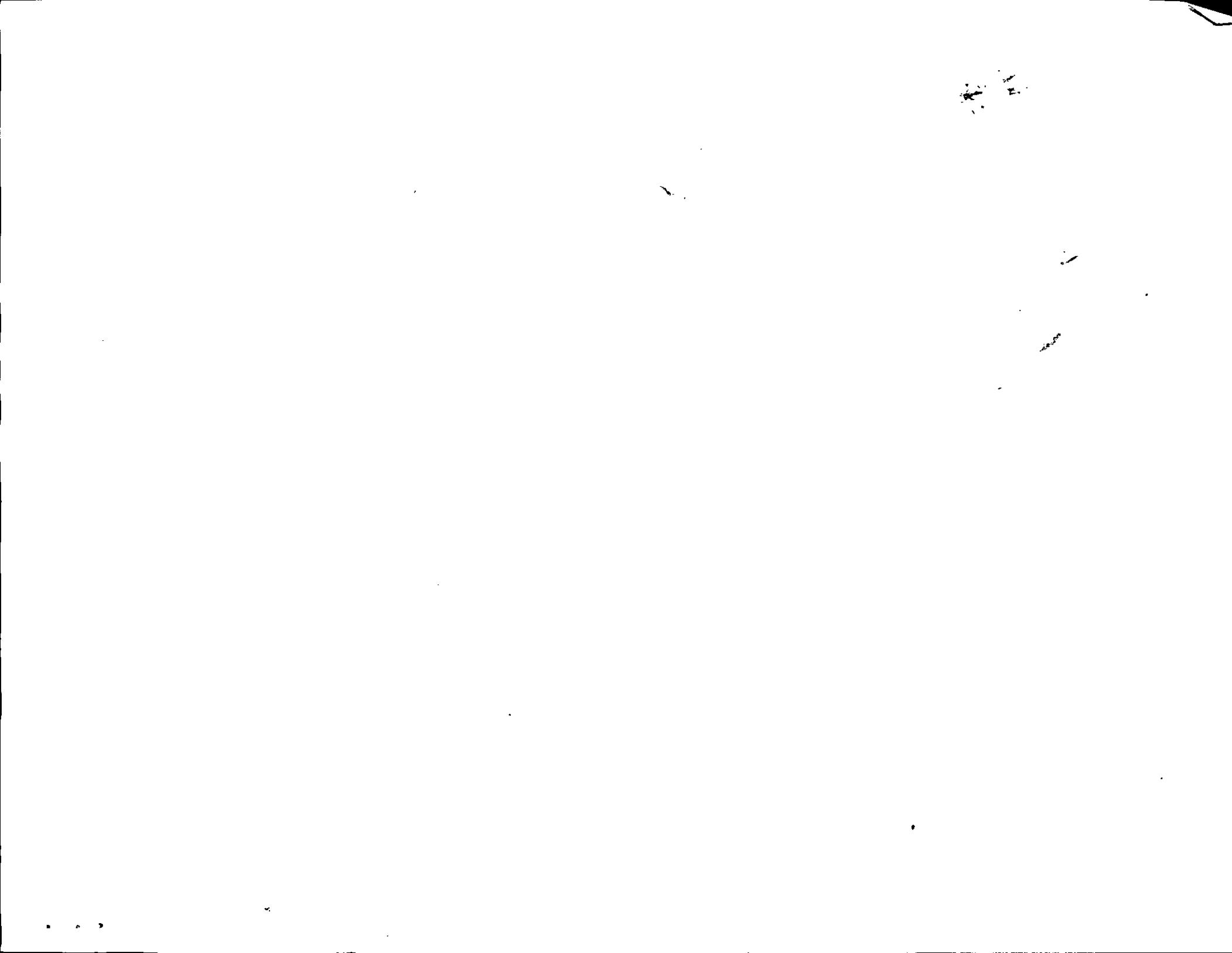
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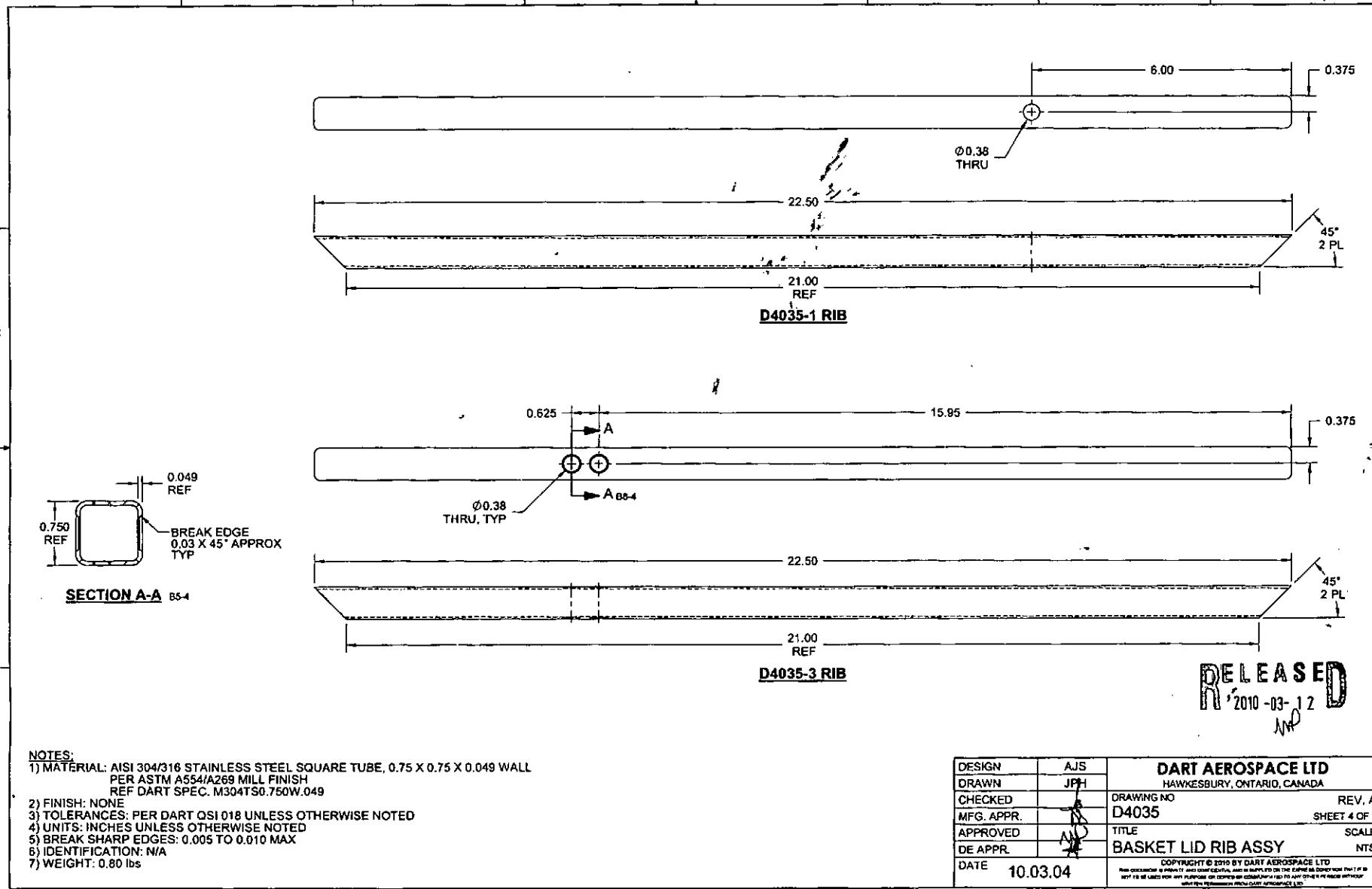
NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.34 lbs
 8) WELDING: PER DART QSI 004

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APPROVED		D4035
DE APPR.		SHEET 3 OF 5
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		NTS
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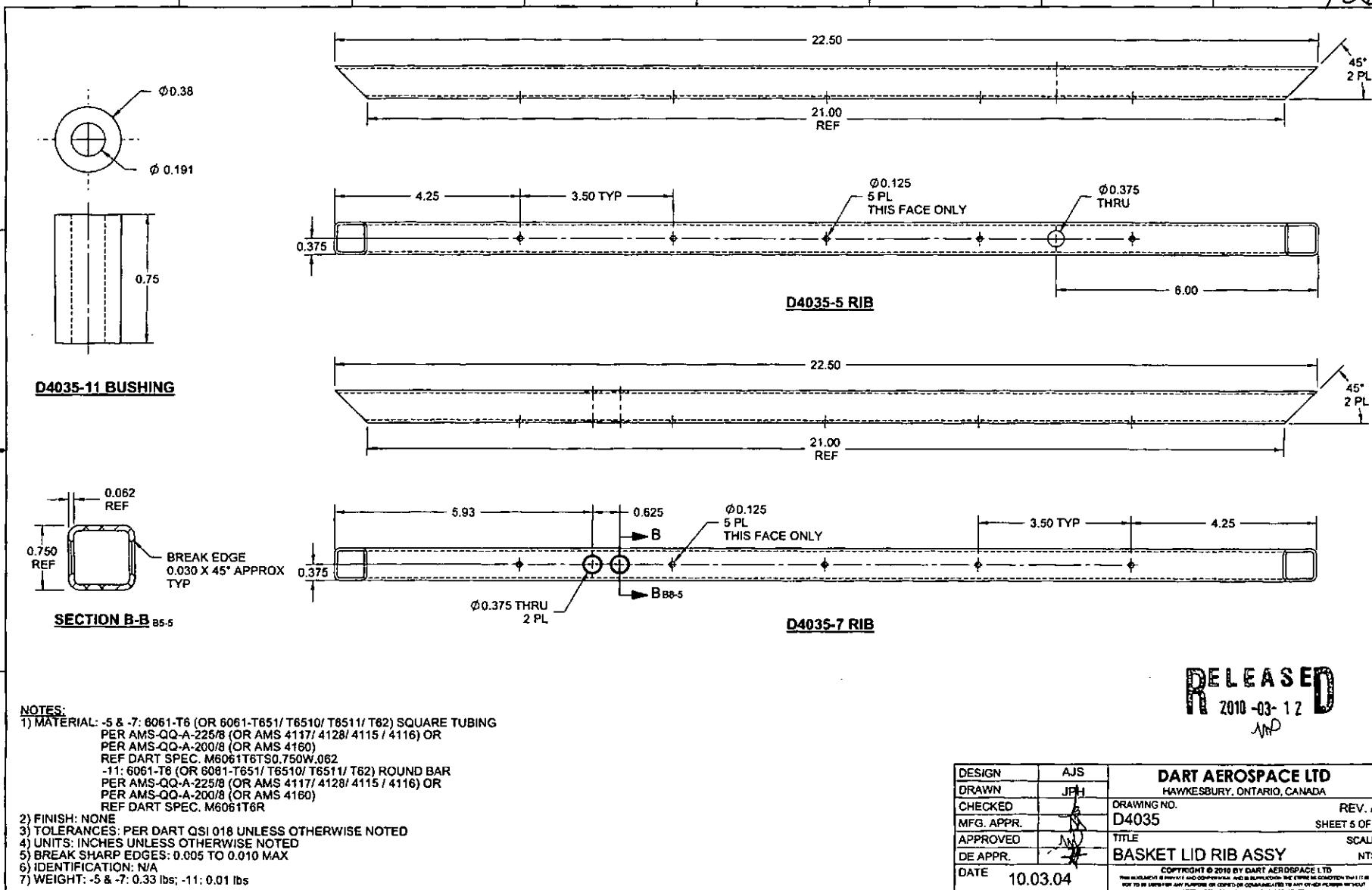


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MFG. APPR.		D4035	SHEET 4 OF 5
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		SCALE
		NTS
		BASKET LID RIB ASSY

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